



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3145-1
Job Sheet 202240



Part No: D3145-1

Job Qty: 6 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 03.02.28 New issue KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		11/1/19	0.00	0.12	Bandsaw - 1		B7-A-10-29
110	HAAS 4 Axis - B4B	6 pcs		11/1/19	1.00	12.43	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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CANADA
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Container No: S227853



Part: D3145-1

Job No: 202240

Serial No/Batch: S227853

Revision:

Inspector:

Print Date:

Instructions: Various STC's

Date: 10/29/19

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130 QC 8	6 pcs	11/1/19	0.00	0.00	QC 2 - 63	
					QC 2 - 8	S. 19-11-03
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	19/11/05
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	11/1/19	0.00	0.72	QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 05 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 -	

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	6 pcs	11/1/19	0.00 0.25	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	6 pcs	11/1/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	6 pcs	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

BL 10-11-5

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					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					QC 21 - SA - 21	CA 002 NOV 05 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: (2.00" x 2.00") x 4,500" (+0.030/-0.00) Long Bar
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine per Folio FA318 and Dwg D3145 Deburr and Tumble
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:05 OVEN TEMPERATURE: 320°
 FINISH TIME: 11:21
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	2.4000 ft (.4 ea)	100-Bandsaw - 1	S225342

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X02.000	2	13	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.240inches ± 0.010	0.250 0.230		
2	Bracket	0.180inches ± 0.010	0.190 0.170		
3	Bracket	0.250inches ± 0.010	0.260 0.240	Radius	
4	Bracket	1.250inches ± 0.010	1.260 1.240		
5	Bracket	1.960inches ± 0.010	1.970 1.950		
6	Bracket	0.221inches ± 0.010	0.231 0.211	Diameter	
7	Bracket	0.351inches ± 0.010	0.361 0.341		
8	Bracket	0.108inches ± 0.010	0.118 0.098		
9	Bracket	0.125inches ± 0.010	0.135 0.115		
10	Bracket	1.636inches ± 0.010	1.646 1.626		
11	Bracket	0.188inches ± 0.010	0.198 0.178	Radius	
12	Bracket	0.125inches ± 0.010	0.135 0.115		
13	Bracket	95.000Degrees ± 0.500	95.500 94.500	Angle	
14	Bracket	0.387inches ± 0.010	0.397 0.377	Radius	
15	Bracket	0.766inches ± 0.010	0.776 0.756		
16	Bracket	0.250inches ± 0.010	0.260 0.240		
17	Bracket	1.370inches ± 0.010	1.380 1.360		
18	Bracket	0.760inches ± 0.010	0.770 0.750		
19	Bracket	4.303inches ± 0.010	4.313 4.293		
20	Bracket	0.219inches ± 0.010	0.229 0.209		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equipment/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____

DART AEROSPACE LTD		Work Order: 202240
Description: Bracket		Part Number: D3145-1
Inspection Dwg: D3145	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	+/-0.010	0.237	✓		Vern	GA-13
0.180	+/-0.010	0.179	✓		"	"
R0.250	+/-0.010	R0.250	✓		R-G	ref.
1.250	+/-0.010	1.250	✓		Vern	GA-13
1.960	+/-0.010	1.960	✓		"	"
Ø0.221 x 0.351	+/-0.010	Ø0.219 x 0.350	✓		"	"
0.108	+/-0.010	0.112	✓		"	"
0.125	+/-0.010	0.130	✓		Mic	118-120
1.636	+/-0.010	1.638	✓		H-G	31006
R0.188	+/-0.010	R0.188	✓		R-G	ref.
0.125	+/-0.010	0.116	✓		Mic	GA-03
95°	+/-0.5°	95°	✓		Angle M.	CNC-17
R0.387	+/-0.010	R0.387	✓		R-G	ref.
0.766	+/-0.010	0.770	✓		H-G	31006
0.250	+/-0.010	0.252	✓		D-G	GA-08
1.370	+/-0.010	1.362	✓		H-G	31006
0.760	+/-0.010	0.760	✓		"	"
4.303	+/-0.010	4.296	✓		"	"
0.219	+/-0.010	0.215	✓		Vern	GA-13

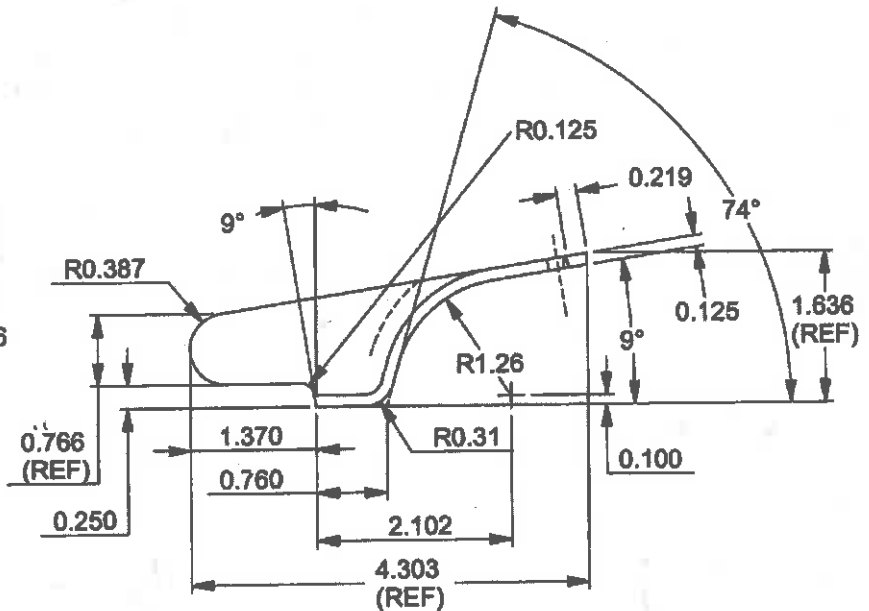
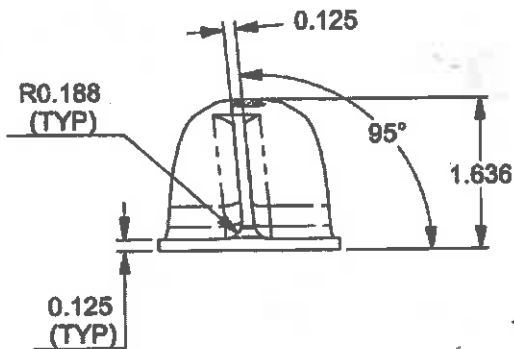
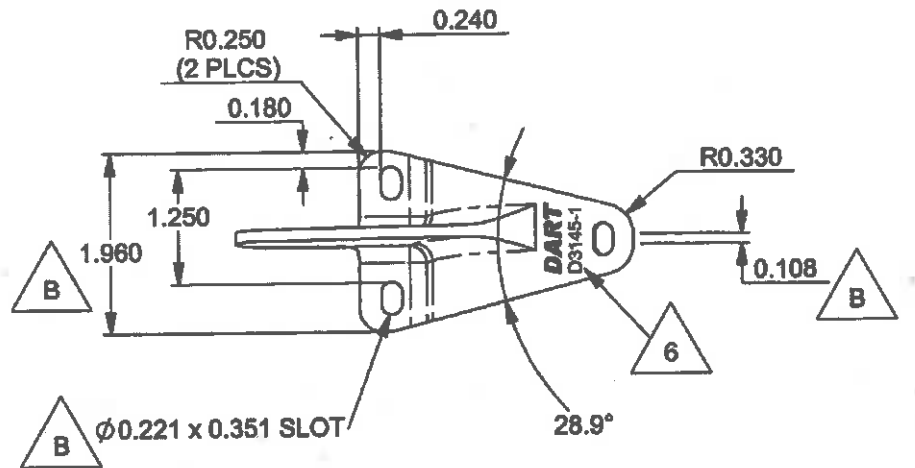
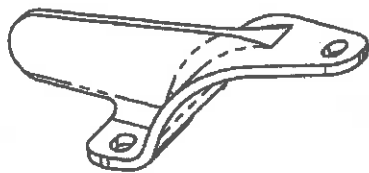
Measured by: De	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19-11-03	Date: 19/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM [Signature]	[Signature]

DART

DESIGN <i>TF</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>UP</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06	TITLE BRACKET	SCALE 1:2	
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.16



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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